

# Work Order ID 60994

August 3, 2010 3:20:32 PM



**PRELIMINARY ISSUE**

Page 1

Item ID: D3417-9

Accept



Setup Start



Revision ID: PRELIM

Item Name: Washer

Stop



Start Date: 03/08/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 10/08/2010 Req'd Qty: 20.00

Customer:



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3417

PE1 F *[Signature]*

100

0.00



Hardinge CNC LATHE SMALL

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA954

Folio Rev: *N/A*

Dwg D3417 Rev: *PE1*

2-Deburr

*SL 10/08/05*



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SL 10/08/05*

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Page 2

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	<i>JS 10/25/08</i>				5		
			<i>- inspect to PFI Day only</i>						
			<i>8/10/08 vs</i>						
			<i>Re inspect to Rev F Day</i>						
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>33</i>  Memo	0.00  0.00	<i>8/13/14</i>				<i>11/3/14</i>	<i>32</i>	
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00	<i>11/3/14</i>						

POSITIVE RECALL

EFFECTIVE *10/24* AUTH *LS*  
RELEASED *10/24* DATE *10/24/14*

*unc*  
*11-03-14*

# Picklist Print

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Page 1

Work Order ID: 60994

Parent Item: D3417-9

Parent Item Name: Washer



Start Date: 03/08/2010

Required Date: 10/08/2010

Start Qty: 20.00

Required Qty: 20.00

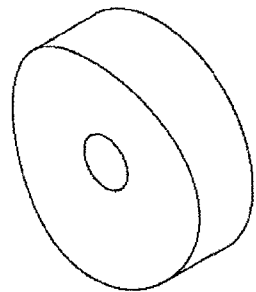
Comments: Ipp Rev:A New Issue 10-08-03 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR1.2500		Purchased	No				f	32.1500	0.0296	0.623158			
DELRIN ROUND BAR 1.25"													

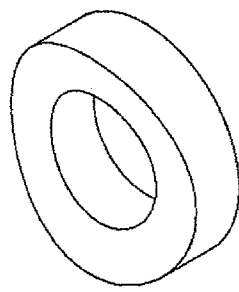
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	32.15	
114586	19.3	
114733	12.85	

.62

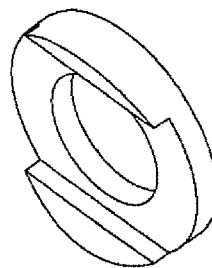
DL 10/08/05



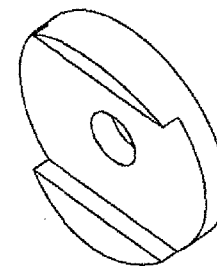
**D3417-1 WASHER**



**D3417-3 WASHER**

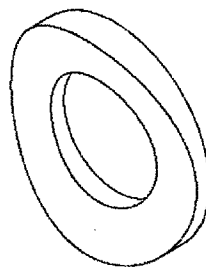


**D3417-5 WASHER**



**D3417-7 WASHER**

*w/o 60994*



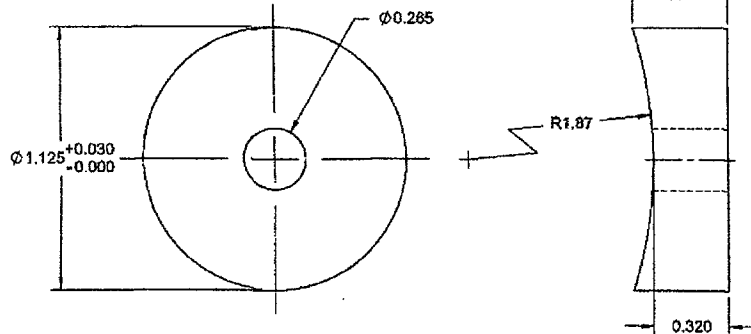
**D3417-9 WASHER**



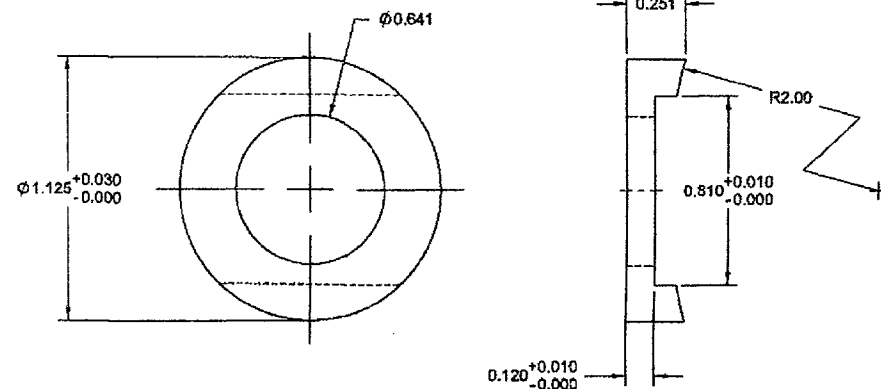
**NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD  
REF DART SPEC M-DELIN-R  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR  
REF DART SPEC M-DELIN-B  
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET  
REF DART SPEC M-DELIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs  
D3417-3, 0.010 lbs  
D3417-5, 0.010 lbs  
D3417-7, 0.010 lbs  
D3417-9, 0.004 lbs

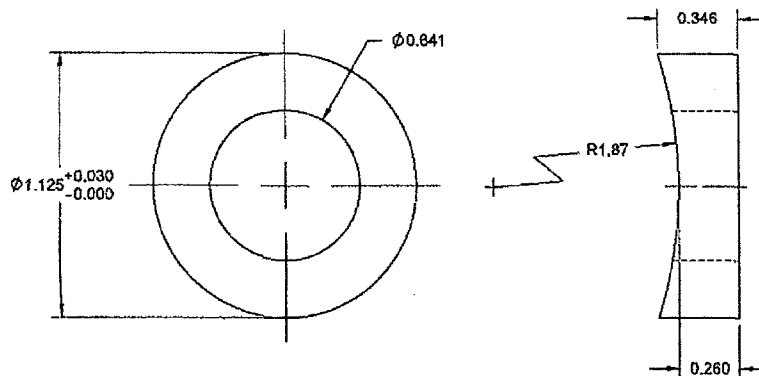
PF1	ADD D3417-9	SC	09.07.26
E	ADD D3417-7 (ZIN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZIN B2-1, B2-2); REFORMAT TO 'B' SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	06.07.08
C	REMOVE CSORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.05.10
A	NEWISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. PF1
MFG. APPR.		<b>D3417</b>	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>WASHER</b>	NTS
DATE	10.07.26	COPYRIGHT © 2035 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO PARTS MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



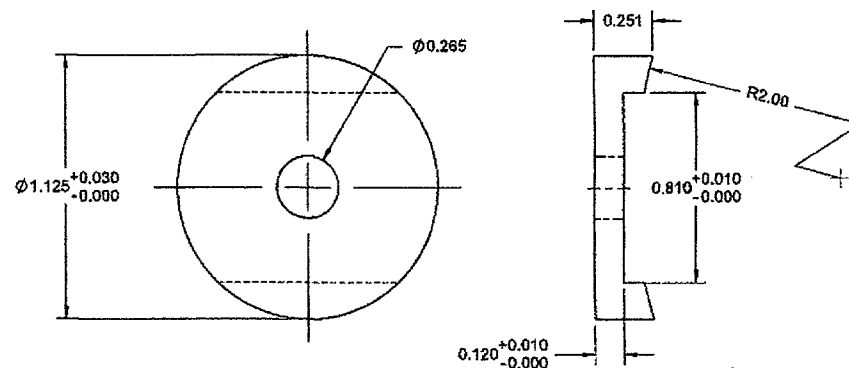
**D3417-1 WASHER**



**D3417-5 WASHER**




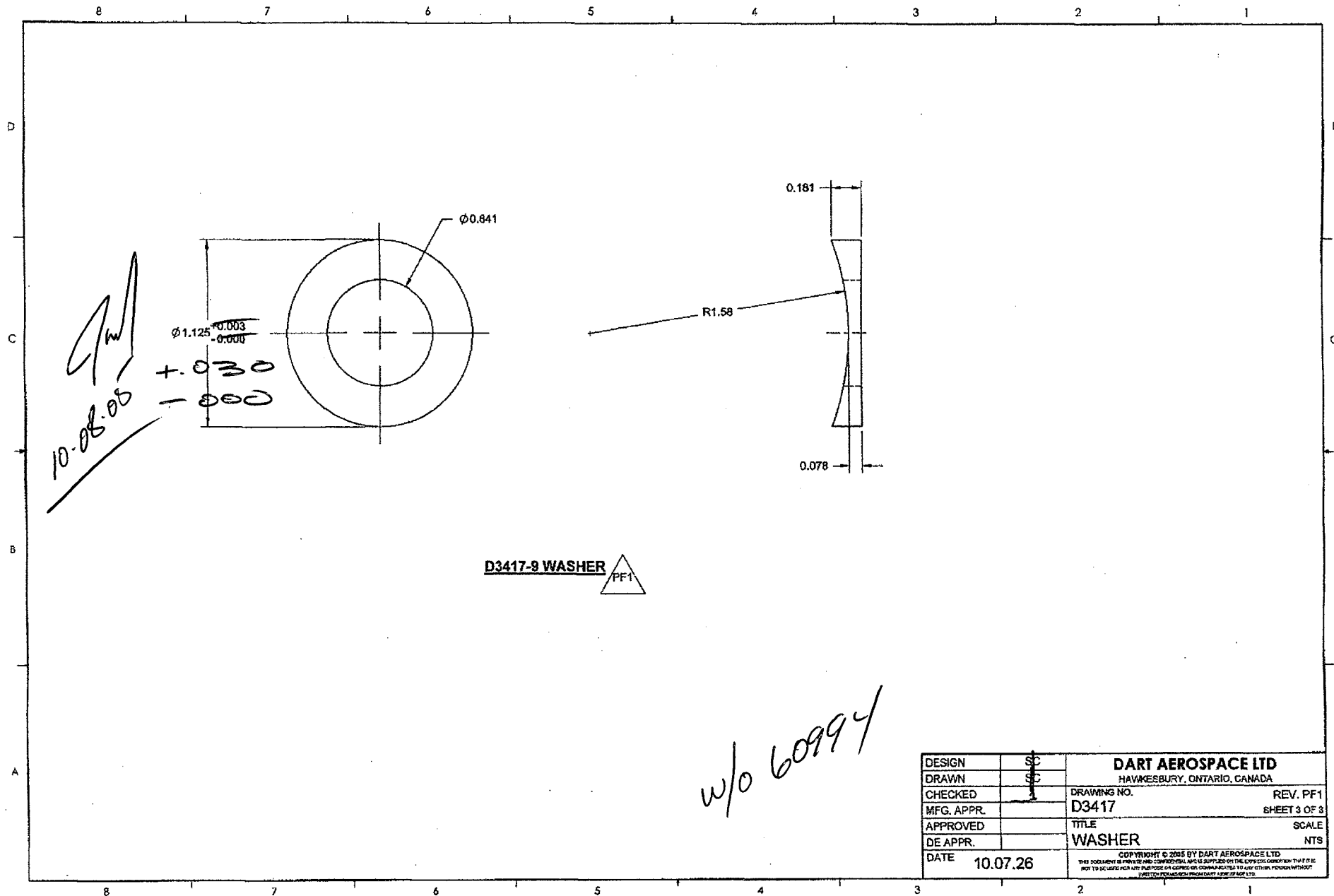
**D3417-3 WASHER**



**D3417-7 WASHER**

w/o 60994

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PF1
MFG. APPR.		D3417	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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# FIRST ARTICLE INSPECTION CHECKLIST

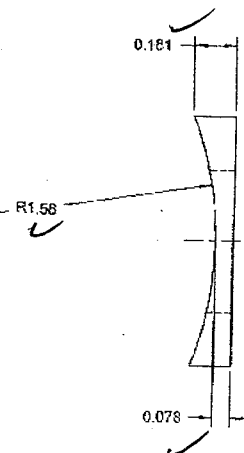
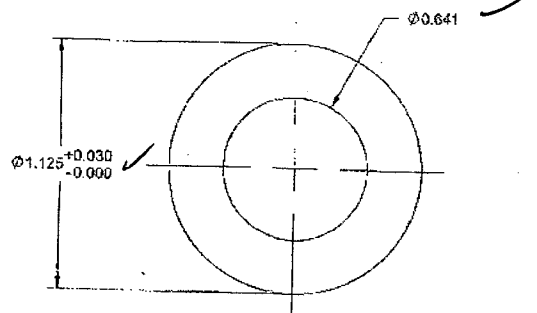
Measured by: <i>SL</i>	Audited by: <i>SL</i>	Preliminary Approval:
Date: <i>10/08/05</i>	Date: <i>10/08/05</i>	Date:

*no PPT Dig only*

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

Reinspected Per  
P. Dwy.  
8/11/03/14

10.04.15



**D3417-9 WASHER**

**RELEASED**  
2010-09-15

DESIGN	SC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO.	REV. F
MFG. APPR.		<b>D3417</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>WASHER</b>	NTS
DATE	10.07.26	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD          THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	